

**AMENDMENTS TO THE CLAIMS:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**LISTING OF CLAIMS:**

1. (currently amended) Method for gluing together two disc halves (5, 21) to produce a disc (23), ~~for example an optical data carrier, such as a DVD,~~ comprising the steps of:

- placing ~~one~~ a first disc half (5) on a rotary member (3, 4);

- applying a quantity of glue (20) to the first disc half (5) in a central region thereof;

- placing a ~~the~~ second disc half concentrically onto the first disc half (5), so as to enclose the glue (20);

- rotating the rotary member (3, 4) with the two disc halves (5, 21) in such a manner that, under the influence of the centrifugal force which is generated, the glue (20) spreads along an expanding front between the two disc halves (5, 21);

- stabilizing the glue which is immediately behind the glue front by means of a light source being displaced in a radial direction following the progression of the glue front ~~radiation~~;

- curing the glue (20);

- removing the glued-together disc halves (5, 21) from the rotary member (3, 4).

2. (original) Method according to Claim 1, comprising the step of stabilizing the glue behind the glue front by means of UV light radiation.

3. (currently amended) Method according to Claim 1, ~~wherein, for gluing together two disc halves (5, 21) which are each provided with a central hole (6), comprising the steps of:~~

~~- the rotary member comprises a mandrel and placing one disc half (5) on a rotary member (3, 4) provided with a mandrel (7) in such a manner that the mandrel (7) fits through the central hole (6) in the first said disc half (5);~~

~~- expanding the mandrel (7) is expanded in such a manner that it the mandrel comes to bear flush against the wall of the central hole (6) of the first disc half which was put in place first;~~

~~----- then applying the quantity of glue (20) to the said disc half (5);~~

~~----- placing the second disc half concentrically onto the first disc half (5) over the mandrel (7), so as to enclose the glue (20);~~

~~----- rotating the rotary member (3, 4) with the two disc halves (5, 21) in such a manner that, under the influence of the centrifugal force which is generated, the glue (20) spreads along an expanding front between the two disc halves (5, 21);~~

~~\_\_\_\_\_ stabilizing the glue which is immediately behind the  
glue front by means of light radiation;~~

~~\_\_\_\_\_ curing the glue (20);~~

~~\_\_\_\_\_ removing the glued-together disc halves (5, 21) from  
the rotary member (3, 4) and the mandrel (7).~~

4. (currently amended) Method according to Claim [[1]]  
3, comprising the step of providing a mandrel (7) which has a  
relatively hard core (8) and a flexible sleeve which surrounds  
the core (18), and expanding the sleeve (12) by means of  
compressed air.

5. (currently amended) Method according to claim 1,  
wherein, comprising the steps of:

the rotary member is a mandrel,

~~\_\_\_\_\_ putting the first disc half (5) in place;~~

~~\_\_\_\_\_ then expanding the mandrel (7) is expanded after  
having the first disc half placed thereupon;~~

~~\_\_\_\_\_ then applying glue (20) to the first disc half (5);~~

~~\_\_\_\_\_ then placing the second disc half (21) is placed over  
the expanded mandrel (7), taking with it any glue (20) adhering  
thereto.~~

6. (currently amended) Device for gluing together two  
disc halves (5, 21) to produce a disc (23), ~~for example an  
optical data carrier such as a DVD,~~ using the method according to  
Claim 1, comprising a rotatable carrier (3, 4) on which the disc

halves (5, 21) can be accommodated, characterized in that a light radiation source is provided which emits a light beam for curing the glue,

wherein the light beam can be displaced in the radial direction with respect to the mandrel.

7 (cancelled)

8. (withdrawn) Device according to Claim 6 for gluing together two disc halves (5, 21) which are each provided with a central hole (6), in which the carrier (3, 4) is provided with a mandrel (7) which can be fitted through the central holes (6) in the disc halves, the mandrel (7) being expandable in the radial direction.

9. (currently amended) Device according to Claim [[7]] 6, in which the mandrel (7) comprises a central core (8) and a flexible sleeve (12) which is connected to the core (8) in an airtight manner, which core (8) has an air-supply duct (9, 10) which opens out into the interior of the flexible sleeve (12).

10. (currently amended) Device according to Claim [[7]] 6, in which the mandrel (7) comprises a cylindrical core (8) provided with a central air-supply duct (9) to which at least one radial transverse duct (10), which opens out on the outer surface of the core (8), is connected.

11. (withdrawn) Device according to Claim 10, in which the core (8) comprises a constricted region (11) in which the sleeve (12) is accommodated.

12. (withdrawn) Device according to Claim 11, in which the sleeve is clamped in at both ends between a clamping ring (15, 16).

13. (withdrawn) Device according to claim 6, in which the sleeve (12) has at least one internal recess (13), and the mandrel (7) has at least one corresponding ridge (14) which engages in the recess (13).

14. (new) Method for gluing together two disc halves (5, 21) to produce an optic data carrier (23), comprising the sequential steps of:

- placing a first disc half (5) on a rotary member (3, 4);
- applying a quantity of glue (20) to the first disc half (5) in a central region thereof;
- placing a second disc half concentrically onto the first disc half (5) so as to enclose the glue (20);
- rotating the rotary member (3, 4) with the two disc halves (5, 21) in such a manner that, under the influence of the centrifugal force which is generated, the glue (20) spreads along an expanding front between the two disc halves (5, 21);

- stabilizing the glue which is immediately behind the glue front by light radiation applied from a light source being displaced in a radial direction following the progression of the glue front;

- finally curing the glue (20); and

- removing the glued-together disc halves (5, 21) from the rotary member (3, 4).